

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011881**Date Inspected:** 28-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG COMPONENT		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as portion of Segment 8CE.

The Weld Designations are as follows

SEG048B-038,016,012,010,013,015,014,036,042,037,022,023,024,044

SSD15-PP71-104,131,191,128,127

SSD15A-PP71-105,130,138,126,127

SEG048J-091,088,097,100,124,127,133,136

SSD17-PP69-140,144

SSD18-PP70-140,148

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 8CE, this Quality Assurance Inspector (QA) discovered that Two (2) Class "A" longitudinal indications measuring approximately 70mm and 220mm in length. The indication db ratings are +4 and -3 respectively.

WELDING INSPECTION REPORT

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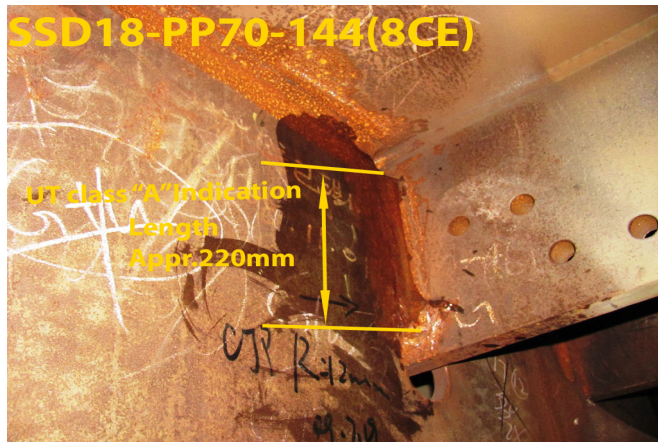
Material thickness is 18mm. The depth of the indications are approximately 14mm and 11mm.

The 1st weld is identified as SSD18-PP70-144 at Panel Point PP70 Crossbeam Side. The 2nd weld is identified as SSD17-PP69-136 at Panel Point PP69 Crossbeam Side. The welds are designated as Seismic Performance Critical Material (SPCM). The indications found are clearly marked near the weld. The Y locations are 70 mm and 0mm when measured from the deck plate. The welds are shown as fillet welds on the contract drawings but due to excessive gaps at the time of fit up were changed to Complete Joint Penetration (CJP) "T" joints.

The 1st joint joining Floor beam FB28A(X12H) SPCM to Deck plate 'I' stiffener RS62HA (Non SPCM). The 2nd joint joining Floor beam FB24A (X25B) SPCM to Deck plate 'I' stiffener RS62HA (Non SPCM).

This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
